

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014217**Date Inspected:** 21-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG Sub-Assembly	

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This Quality Assurance Inspector performed document control for Phased Array Ultrasonic Testing Training, including copying training documents and development of trainee binders with literature for training class and preparation of material prior to class being given at the above-mentioned location.

This QA Inspector performed a survey of on-going work being performed in Sub-Assembly Bays 1 thru 9 with the following results:

BAY 1

Traveler Rail (New Production): 34 – Rails 40% welding complete; no NDE or HSR performed.

8 – Rails 60% welding complete; no NDE or HSR performed.

45 – Rails welding complete; no HSR performed; VT in process.

24 – Rails welding complete; no HSR performed; NDE in process and

NDE appears to be 100% UT-Reject (each rail not each weld).

CB15: Welding approx. 45% complete. VT pickup in process. 10% ZPMC NDE performed.

Traveler Brackets: 42 Brackets welding complete ZPMC VT/UT OK.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

150 Brackets welding/VT/HSR complete.

21 Brackets ZPMC UT rejected.

BAY 2

Traveler Rail (Repairs): 30 Rails Buttering and UT Repairs complete; HSR and VT Pickup in process.

16 Rails welding complete, VT Pickup in process; No HSR performed; NDE
appears to be 100% UT-Reject (each rail not each weld).

Lift 13W Floor Beams: 39 Floor beams' web splices fit-up in process.

10 Floor beams' web splices fit. Web splice welding in process.

25 Floor beams' web splices complete.

BAY 3

No Mock-Up work.

Traveler Rails (Repairs): 30 Rails CWR/HSR complete; VT pickup in process.

BAY 4

Other projects

BAY 5

Traveler Rails (Repairs): 22 Rails Buttering for length complete; HSR in process.

22 Rails CWR/HSR/NDE complete; FVT in process.

19 Rails CWR complete; NDE in process.

28 Rails Green Tagged.

Traveler Rail Brackets: 40 Brackets welding 50% complete; No HSR/NDE performed.

BAY 6

Jacking Frame- 485 material: Jacking saddle requires 100% MT and 100% UT of CJP welds. Jacking frame
requires 25% MT and 100% UT of CJP welds.

Fit up 80% complete; Welding 40% complete; No NDE performed.

Hand Rails: 20 rails welded with VT pickup in process.

55 Rails VT pickup complete.

BAY 7

Traveler Rails (Repairs): 13 Rails HSR and VT pick-up in process.

29 Rails Buttering and UT Repairs in process.

Lift 13 (Prefab): 8 Deck Panel plates being Cut to size.

12 Bottom Panels HSR in process.

BAY 8

Bike Path: BK004A assemblies being fitup and welded.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Traveler Rails (Repair): 5 Rails CWR in process.

9 Rails HSR in process.

CB17: Side panels to Bottom panel fitup in process.

BAY 9

Lift 13 Deck Panels: U Rib material cut to size (CTS).

Holes for U rib bolted connections in process.

1 - 20mm Deck plate for practice (machine set-up) fit; Tack welds ZPMC MT OK.

31 U ribs with continuity plate welding complete; VT pickup complete; NDE in process.

13 U ribs with continuity plate welding complete; VT pickup in process; No NDE performed.

9 U ribs with continuity plate welding in process.

5 U ribs with continuity plates fitup only.

84 U ribs formed with holes; Continuity plates not fitup.

This QA Inspector gave training to certified level 2 and level 3 UT technicians in the performance of Phased Array Ultrasonic Testing, including Theory, Practical application and Specific requirements.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
